



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pilot Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15533	35/42/55
2	Machined By		V.T.L. m/c Shop	Dy. No. 120/259
3	Pallet Die No.		14432 (6.0) m/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	529.9 m/c	Step 00. 491 m/c
6	Inside Diameter	Drg. No.	420.14 m/c	428.12 m/c
7	Width of Pellet Die	Drg. No.	160 m/c	425.12 m/c
8	Grooves as per Drawing	Drg. No.	10x4x15x35x22.5	10x4x15x3.5x22.5 m/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		m/c Shop	
12	Tapping PCD		455 m/c	
13	Tapping Hole Diameter		03/4" = Check by 03/4" Reel	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 22.4 m/c	Tapping Depth. 20.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/8/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		no

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok								Counter 30
2	External Relief Dia	6.5 m/c	7.0 m/c	6.5 m/c	All Rows 2 go m/c					Row 2 8
3	External Relief Depth			7.0 m/c	All Rows 2 10 m/c					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Porrace					
6	Material Sent For Hardening On Date				8	25				

Inspected By (Sign) & Date

Ravi 11/8/25

Reviewed by (Engineer-CNC)

Manager-QA